

Date: Wednesday, 10/10/2007 11:03:49 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR AFT RH
Job Number : 35085	
Estimate Number : 11235	
P.O. Number : N/A	
This Issue : 10/10/2007 S.O. No. : N/A	Part Number : D32814
Prsht Rev. : NC	Drawing Number : D3281 REV B
First Issue : N/A	Project Number : N/A
Previous Run : 33900	Drawing Revision : B
Written By :	Material : N/A
Checked & Approved By :	Due Date : 11/2/2007
Comment : Est Rev A 04.07.01 New issue KJ/JLM	Qty: 20 Um: Each
Est Rev B 07.08.07 Thermoform in house DL	



UNDER REVIEW  
OK TO PRODUCE  
LE 07.10.2  
LE 08.01.90

Qty 1

## Additional Product



Seq. #: Machine Or Operation: Description :

1.0 F6002 701 lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total : 87.2000 sf(s)  
lexan black .125"

Material Batch # M106713

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



x 10

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

Wh 08.01.05

3.0 THERMOFORMING THERMOFORMING MACHINE



x 10.

Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 010

Dwg. Rev. C  
Folio Rev. B

Wh 08.01.05

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



x 10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Wh 08.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 08/01/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT RH

Job Number: 35085

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

x10

Wh. 08.01.07

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

x10

Wh. 08.01.07

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Wh. 08.01.07 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Wh. 08.01.07

8/10/07

(x10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Wh. 08.01.07

Job Completion



Wh. 08.01.07 (10)

POSITIVE RECALL

EFFECTIVE 08.10.12 AUTH LC

RELEASED Wh. LC DATE 08.01.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

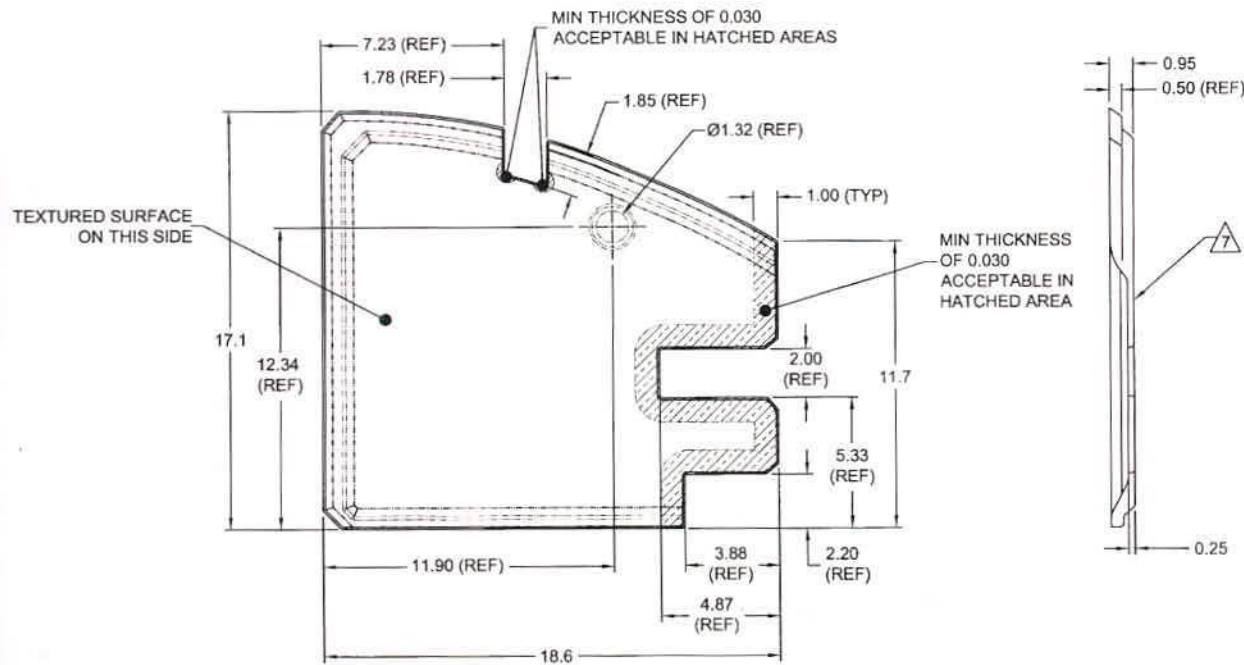


RELEASED  
07-11-06

# D3281-1 FLOOR PROTECTOR

## D3281-1 NOTES:

- 1) TH: RMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb



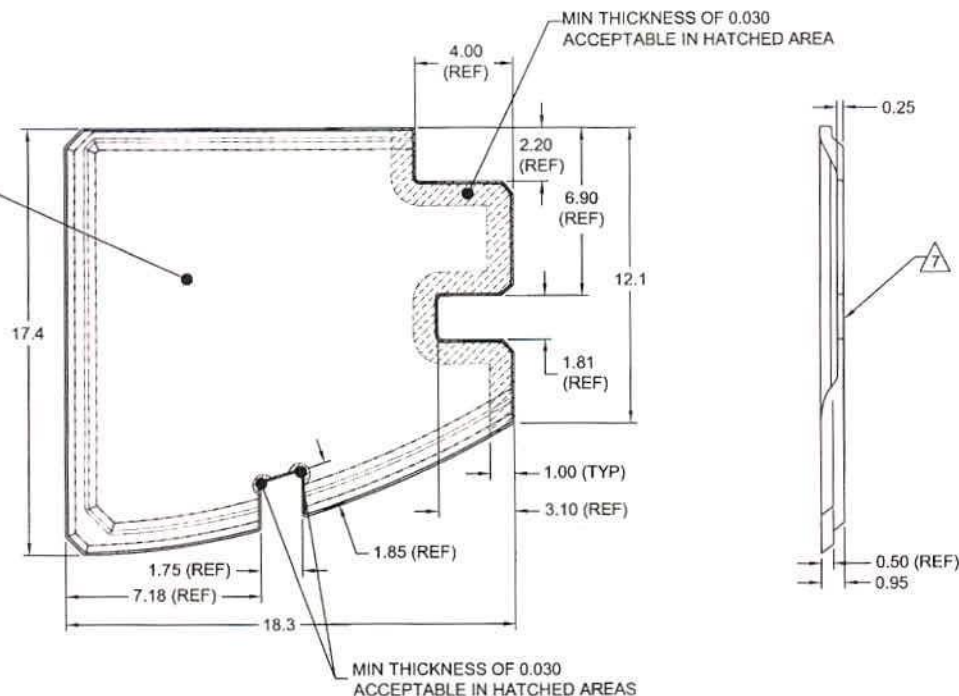
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	LE		
CHECKED	LE		
MFG. APPR.	LE		
APPROVED	LE		
DE APPR.	LE		
DATE	07.10.09		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. C
DRAWING NO.	D3281	SHEET 1 OF 3
TITLE	FLOOR PROTECTOR	SCALE
		NTS

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TEXTURED SURFACE  
ON THIS SIDE



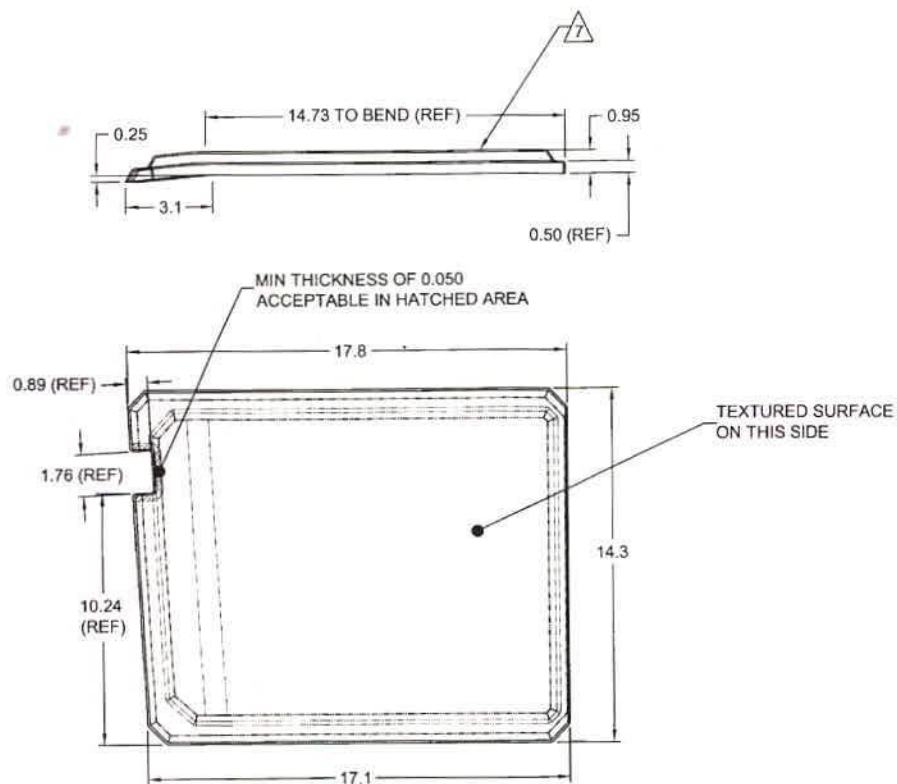
RELEASED  
07.11.06 JAD

# D3281-2 FLOOR PROTECTOR

## D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK (REF DART SPEC MLEXS. 125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	LE	HAWKESBURY, ONTARIO CANADA	
CHECKED	PE	DRAWING NO.	REV. C
MFG. APPR.	AL	D3281	SHEET 2 OF 3
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	FLOOR PROTECTOR	NTS
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RELEASED  
07.11.06

D3281-3 FLOOR PROTECTOR  
(D3281-4 OPPOSITE)

W/O 35085

**D3281-3/-4 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	91	<b>DART AEROSPACE LTD</b>	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	W/O	D3281	SHEET 3 OF 3
APPROVED	W/O	TITLE	SCALE
DE APPR.	W/O	FLOOR PROTECTOR	NTS
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DART AEROSPACE LTD		Work Order: 35085
Description: R44 FLOOR PROTECTORS AFT RH		Part Number: D3281-4
Inspection Dwg: D3281	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>D. Hage</u>	Date: <u>08.01.05</u>
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	.1	17.8	✓			
17.1	.1	17.1	✓			
14.3	.1	14.25	✓			
3.1	.1	3.1				
0.95	.03	0.956				

Measured by: <u>D. Hage</u>	Date: <u>08.01.07</u>
Audited by: <u>[Signature]</u>	Date: <u>08.01.07</u>
Prototype Approval: <u>N/A</u>	Date: <u>[Signature]</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	